

Date: Thursday, 12/20/2007 3:17:12 PM  
 User: Kim Johnston

## Process Sheet

3

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR BRACKET
Job Number	: 36466A		
Estimate Number	: 10142		
P.O. Number	:	Part Number	: D2161204
This Issue	: 12/20/2007 S.O. No. :	Drawing Number	: D2161 REV B2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : SMALL /MED FAB	Drawing Revision	: B2
Previous Run	: 29082A	Material	:
Written By	:	Due Date	: 1/15/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>12071221</u>		
Comment	: Est Rev:A New Issue 05-11-01 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	36466A01	MIRROR BRACKET
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Comment: Sub-Component MIRROR BRACKET  
 D2013-5 B 36466 A01

FC 08 01 14 (S)

2.0	36466A02	MIRROR BRACKET
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Comment: Sub-Component MIRROR BRACKET  
 D2013-6 B 36466 A02

FC 08 01 14 (S)

3.0	36466A03	ARM
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Comment: Sub-Component ARM  
 D2037-101 B 36466 A03

FC 08 01 14 (S)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Assemble on Jig DT8065 as per Dwg D2161

FC

2-Weld as per Dwg D2161 Identify as D2161-204

FC

08/01/14 (S)

5.0	DO NOT USE	WELD INSPECTION
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Comment: WELD INSPECTION

QC5 =&gt; 5060115

QC9 =&gt; PD 080115

(X2)

(X2)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2161-204 PAR #: \_\_\_\_\_ Fault Category: Prod / Fab Large NCR: (Yes) No DQA: 12 Date: 08/01/28  
 QA: N/C Closed: 12 Date: 08 01 28

NCR: <u>36466 A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/15	# 40	3 <del>are</del> complete mirror Brackets were welded wrong. The "Equal Distance" is off by at least 3/16"	<u>[Signature]</u> 08/01/15	Scrap and Destroy No Replace. QTY (X3)	<u>KE</u> 08/01/15	<u>[Signature]</u> 08/01/15	<u>[Signature]</u> 08/01/15	<u>[Signature]</u> 08/01/15
		R.C. Human Error						
08/01/15	# 40	1 complete mirror Bracket was welded wrong. The "Equal Distance" is off by 1/8"	<u>KE</u> 08.01.15	Part is acceptable. This one time only	<u>KE</u> 08/01/15	<u>[Signature]</u> 08/01/15	<u>KE</u> 08.01.15	<u>[Signature]</u> 08/01/15

NOTE: Date & initial all entries R.C. Human error

Date: Thursday, 12/20/2007 3:17:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 36466A

Part Number: D2161204

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M100 700



(2X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 08/01/18

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/1/01 50

(2X)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.22

Job Completion



08.01.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

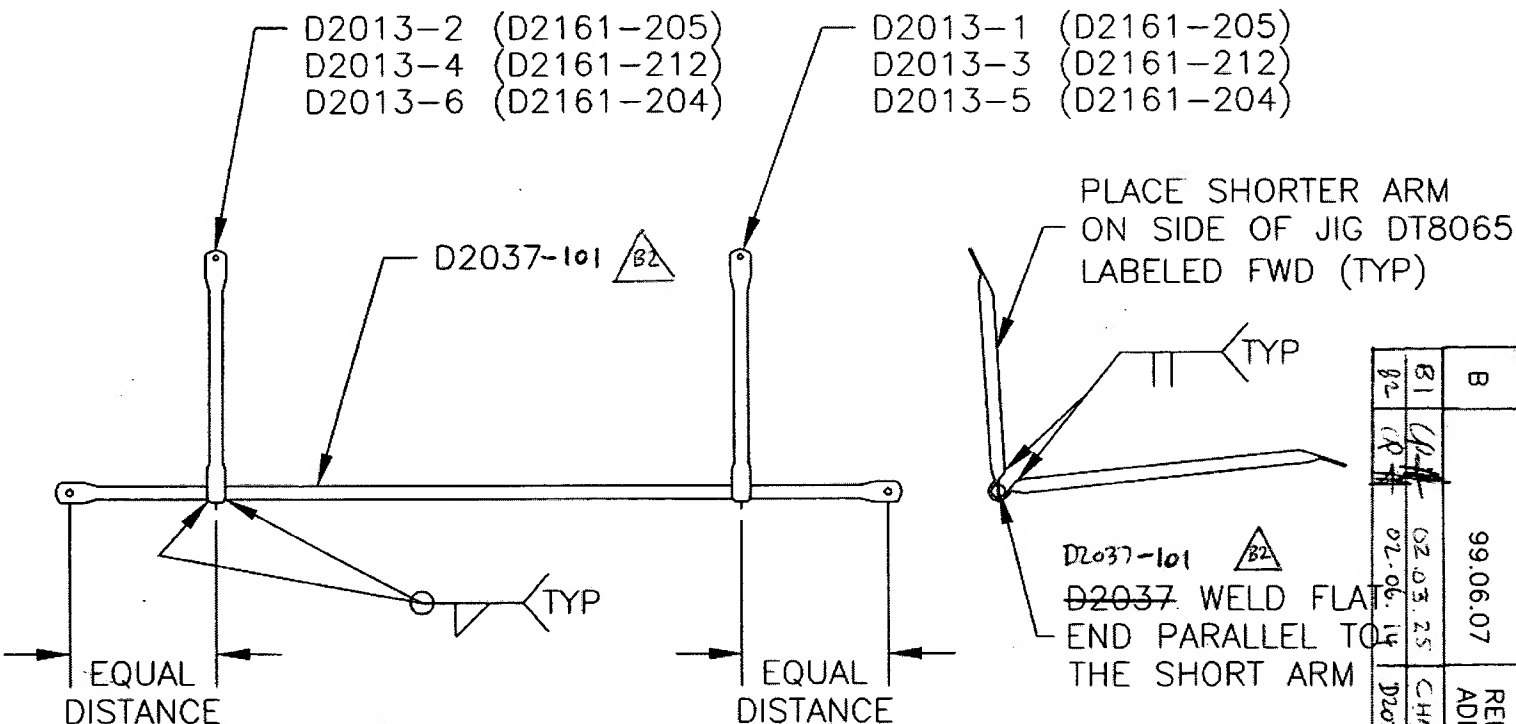
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
JB	RT		
CHECKED KE	APPROVED RT	DRAWING NO. D2161	SHEET 1 OF 1
DATE 99.06.07		TITLE MIRROR BRACKET	SCALE NTS
A	93.04.29	NEW ISSUE	
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS	
B1	02.03.25	CHANGE FINISH	
B2	02.06.14	D2037-101 WELD	

**RELEASED**  
KE 99.06.10

DETAIL OF D2161-204  
DETAIL OF D2161-205  
DETAIL OF D2161-212

**NOTE:** WELD ASSEMBLY  
USING JIG DT8065

ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36466A  
~~POWDER COAT ASSEMBLY BLACK~~  
~~POWDER COAT BLACK SANDTEX (4.3.5.7) PER~~  
~~DART QSI 005 4.3~~ (B1)